



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3914-041
Job Sheet 183329



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Large Fab-5		28-09-18
100	Large Fab	1 pcs	10/12/18	10/12/18	0.00	6.67	Large Fab 1		28-09-18
110	QC	1 pcs	10/12/18	10/12/18	0.00	0.00	QC9		
120	QC	1 pcs	10/12/18	10/12/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs	10/12/18	10/12/18	0.00	0.40	Powdercoat4		28-09-18
135	QC	1 pcs	10/12/18	10/12/18	0.00	0.00	QC3		18-10-19
140	HandFinish	1 pcs	10/12/18	10/12/18	0.00	0.80	HandFinish3		18-10-19
150	QC	1 pcs	10/12/18	10/12/18	0.00	0.00	QC3		18-10-19
160	Packaging	1 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2		18-10-19
170	QC21-SA	1 Ea	10/12/18	10/12/18	0.00	0.00	QC21		21 OCT 19 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138839 START: 2:40 TEMP: 320° FINISH: 3:10

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5112316
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5108958
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5109117 (2) 5110937 (2)
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5110523
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5113734
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5069261
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5111126

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
-----------	----------------	----------	-----------	-----------

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

90-Start up Operation

D2581	2	92	0
D3914-1	2	11	0
D3914-7	2	16	0
D4016-3	3	22	0
D4018-5	9	57	0
D4020-5	1	2	0
D4021-3	1	14	0
D4035-043	2	14	0

Part Specifications

Specifications could not be found.

Plex 9/17/18 7:41 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date : _____ Step : _____

Description Work Ord

DART



Master Unit 005640

Job No 183329

DART
AEROSPACE

Container No: S114081

Part: D3914-041

Job No: 183329

Serial No/Batch: S114081

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/27/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K8A 1A7
CANADA
TEL: 1 613 622-5200
Email: sales@dartero.com
www.dartaerospace.com

Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

FAULT CATEGORY

☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

OTHER :